



Dart Aerospace Ltd.
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D3859-041
Job Sheet 188970



Part No: D3859-041

Job Qty: 16 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/3/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: D3859 REV.C IPP Rev:A 09-02-03 new issue DD verified by:EC IPP Rev:B 14.04.30 as per dwg rev.b DD verified by:JLM IPP REV:C 17.11.17 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		2/3/19	0.00	2.46	Waterjet - Flow		SC 19.02.12
110	QC	16 pcs		2/3/19	0.00	0.00	QC2 Waterjet-2		SC 19.02.12
120	QC	16 pcs		2/3/19	0.00	0.00	QC8-3		PD 19-02-13
130	Large Fab	16 pcs		2/3/19	0.00	27.12	Large Fab 1		TBL
135	Autoweld 1	16 pcs		2/3/19	0.00	1.60	Automated welding		TBL
140	QC	16 pcs		2/3/19	0.00	0.00	QC9		SC 19.02.22
150	QC	16 pcs		2/3/19	0.00	0.00	QC5		SC 19.02.22
180	Packaging	16 pcs		2/3/19	0.00	0.00	Packaging3	STG10	SC 19.02.22
190	QC21-SA	16 Ea		2/3/19	0.00	0.00	QC21		SC 19.02.22

Part Op 100 - 1-Cut as per Dwg D3859-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary 3-88
Descriptions: 130 - 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 2- WELD
HARDCOAT TO BAR 2059B HARDCOAT BATCH: _____ 3- POLISH WELS SURFACE AREA AS PER DWG
NOTE2
135 - AUTO WELD HARDFACING 8259 BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	13.6000 sf (.85 ea)	100-Waterjet - Flow - 1	5152146
D4379-5	Wearplate Cup	96 Ea (6 ea)	130-Large Fab	5138506

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	14	27	0
130-Large Fab	D4379-5	96	234	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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CANADA
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Container No: S153111



Part: D3859-041

Job No: 188970

Serial No/Batch: S153111

Revision: C

Inspector:

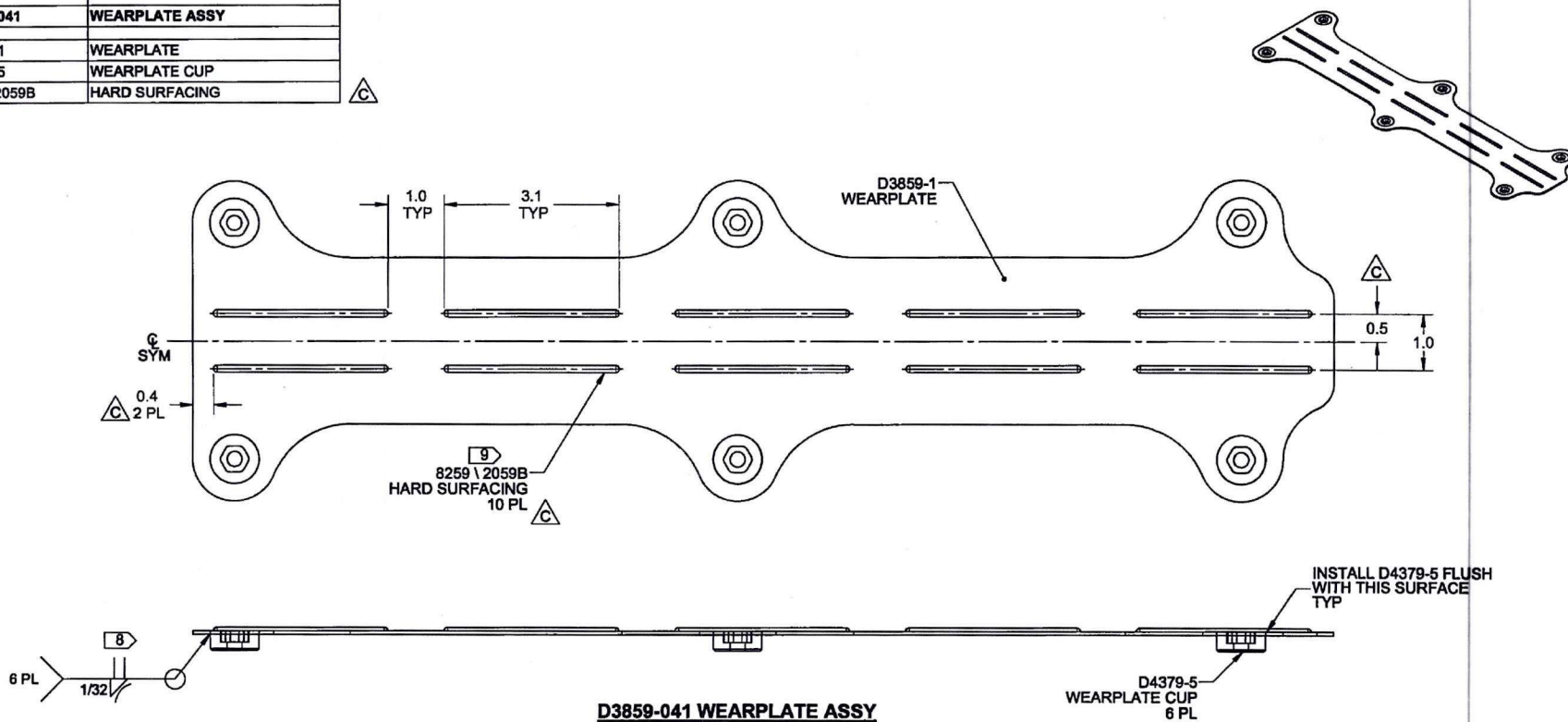
Exp Date:

Instructions: Various STC's

Date: 02/12/19

20 160970
20 160970
041

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE ASSY
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP
3	A/R	8259 \ 2059B	HARD SURFACING

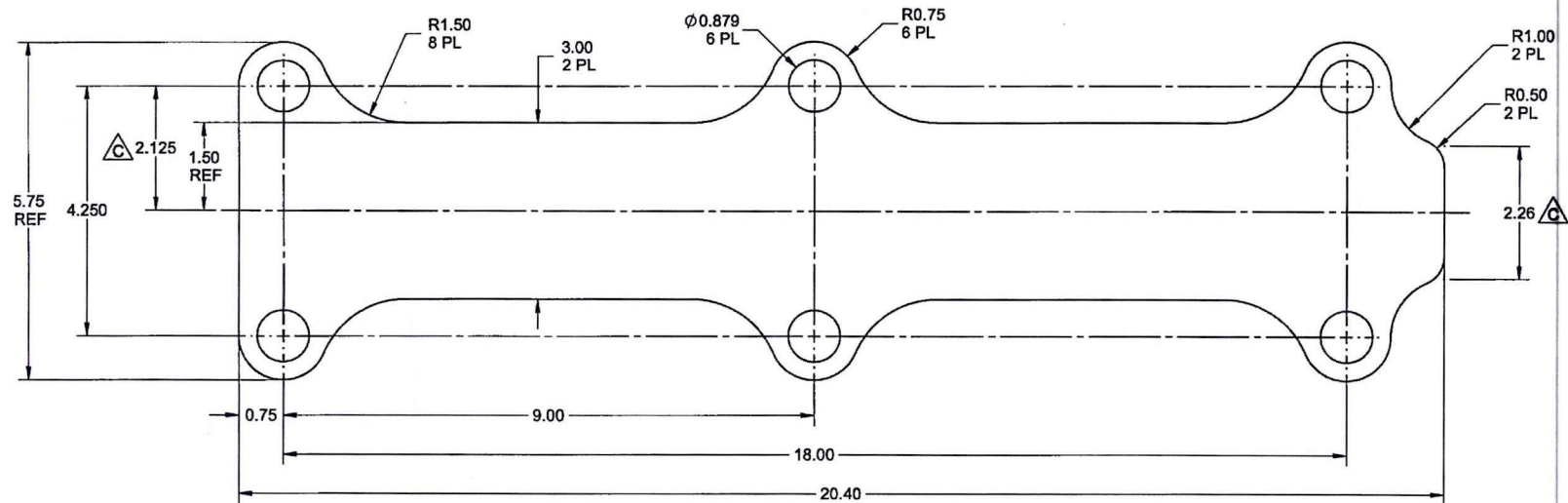


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POLISH WELD SURFACE AREA
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2017-11-15
50N 17-150

C	SHEET 1: ADDED NOTE 9 FOR AUTOMATED WELDING. UPDATED NOTE 2 FOR POLISHING WELD, UPDATED WELD SPACING DIMENSIONS, SHEET 2: GENERAL TOLERANCES FOR -1 UPDATED, UPDATED MATERIAL, UPDATED FLAT PATTERN DIMENSIONS.		SAD	16.12.07
B	D4379-5 CUP WELD D3009-3 CUP		DB	14.03.05
A	NEW ISSUE		HS	09.01.28
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SAD			
CHECKED	AJS	DRAWING NO.	REV. C	
MFG. APPR.	DD	D3859	SHEET 1 OF 2	
APPROVED	WM	TITLE	SCALE	
DE APPR.	DS	WEARPLATE	NTS	
DATE	COPYRIGHT © 2009 BY DART AEROSPACE LTD			
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D3859-1F WEARPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

RELEASED
2017-11-15

APPROVED

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D3859	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					